

Work Order ID 135325

Wednesday, September 16, 2015 1:08:21 PM

135325

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Item ID: D2570 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bushing.
Start Date: 8/12/2015 Start Qty: 21.00 ***21*** Cust Item ID:
Required Date: 8/13/2015 Req'd Qty: 21.00 ***21*** Customer: CCANA01
Reference: RMA RA112127

Approvals: Process Plan: MF Date: 15-9-16 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2570	Rev B

100		0.00							
100									DAS
QC		0.00							9

Quality Control Memo
INSPECT RA 112127
D2570 X 21 BXXX
GIVE BUSHINGS TO ENG FOR EVALUATION

110	QC21- Final Inspection - Work Order Release	0.00
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110		
QC	Memo	0.00
Quality Control		

SH 151103

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

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Work Order ID: 135325

135325

Parent Item: D2570

D2570

Parent Item Name: Bushing

Start Date: 8/12/2015

Required Date: 8/13/2015

Start Qty: 21.00

Required Qty: 21.00

Comments: IPP E02.08.29Re-format; Removed finishing; Material changeKJ
IPP F 07.07.06 rev B dwg EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2570		Manufactured	No				Each	203.0000		21			

D2570

Bushing

Location

Loc Qty

Loc Code

FG	12	
88781	12	
FP001	4	
133432	4	
ST008	187	
136166	187	

21 x XXX MF
15-9-16

DQA: _____ Date: _____



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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

RA112127

Received @ august 6, 2015
Inspected@ August 11, 2015

CUSTOMER: CANADIAN HELICOPTERS SERVICES
CUSTOMER CONTACT: CHRIS WIERINGA
SHIPPED FROM: SOUTHPORT MB

Instructions for RA112127 D2570 B#N/A

- Customer is returning 21x D2570
- On one D2570 top section of bushing is completely sheared off. All other bushing as no sign of cracks
- D2570 are all as per drawing
- Give to engineering for evaluation

Time Estimate: N/A

Departments Required: Quality, engineering

Pictures Attached: Yes

QTY INSPECTED: 21x D2570 B# N/A

**THIS INSTRUCTION SHEET
MUST BE ATTACHED TO THE
RESTOCKING WORK ORDER
AT ALL TIMES!!!!**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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